

Date: Tuesday, 3/11/2008 7:57:21 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB ASSEMBLY
Job Number : 37741	
Estimate Number : 10194	
P.O. Number :	Part Number : D2174041
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D2174 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 32856	Material :
Written By :	Due Date : 4/4/2008 Qty: 12 Um: Each
Checked & Approved By : <u>08 03 11</u>	
Comment : Est: D 04.06.10 Reformat; Changed Step 2 KJ/JLM Est Rev:E As per Rev E 06-11-22 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D21741	Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 12
 Web

Qty	Part Number	Description	Batch
1	D2174-1	Web	B31689 ②

~~B37848~~ B37848

SB 08/04/01

⑫

2.0	D21751	Angle LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 12
 Angle LH

Qty	Part Number	Description	Batch
1	D2175-1	Angle	B31691

SB 08/03/25

⑫

3.0	D21752	Angle RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 12
 Angle RH

Qty	Part Number	Description	Batch
1	D2175-2	Angle	B35342

SB 08/03/25

⑫

4.0	MS20470AD46	Rivet, Universal Head
-----	-------------	-----------------------



Comment: Qty.: 19.0000 Each(s)/Unit Total : 190.0000 Each(s) 228 Rivets
 Rivet, Universal Head ✓

Qty	Part Number	Description	Batch
19	MS20470AD4-6	Rivet	M106375 x13

M 107082 x 215

M 08/04/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:21 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 37741

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2174-041

2- Identify as D2174-041

ml 08/04/01 (X12)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/01 (X12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

AS 08-04-02

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-1 08/04/02

(12X)

9.0

AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

Batch: *9216*

AS 08/04/03

(X12)

10.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Batch: *M107091*

AS 08/04/03

(X12)

11.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

Batch: *M106903*

AS 08/04/03

(X12)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install nuts & bolts loosely as per Dwg D2274

CB 08/04/03 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:21 AM
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Drawing Name: WEB ASSEMBLY

Job Number: 37741

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/04/08 x12

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST222

JS 08/04/08 x12

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08 x12

Job Completion



JS 08-04-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

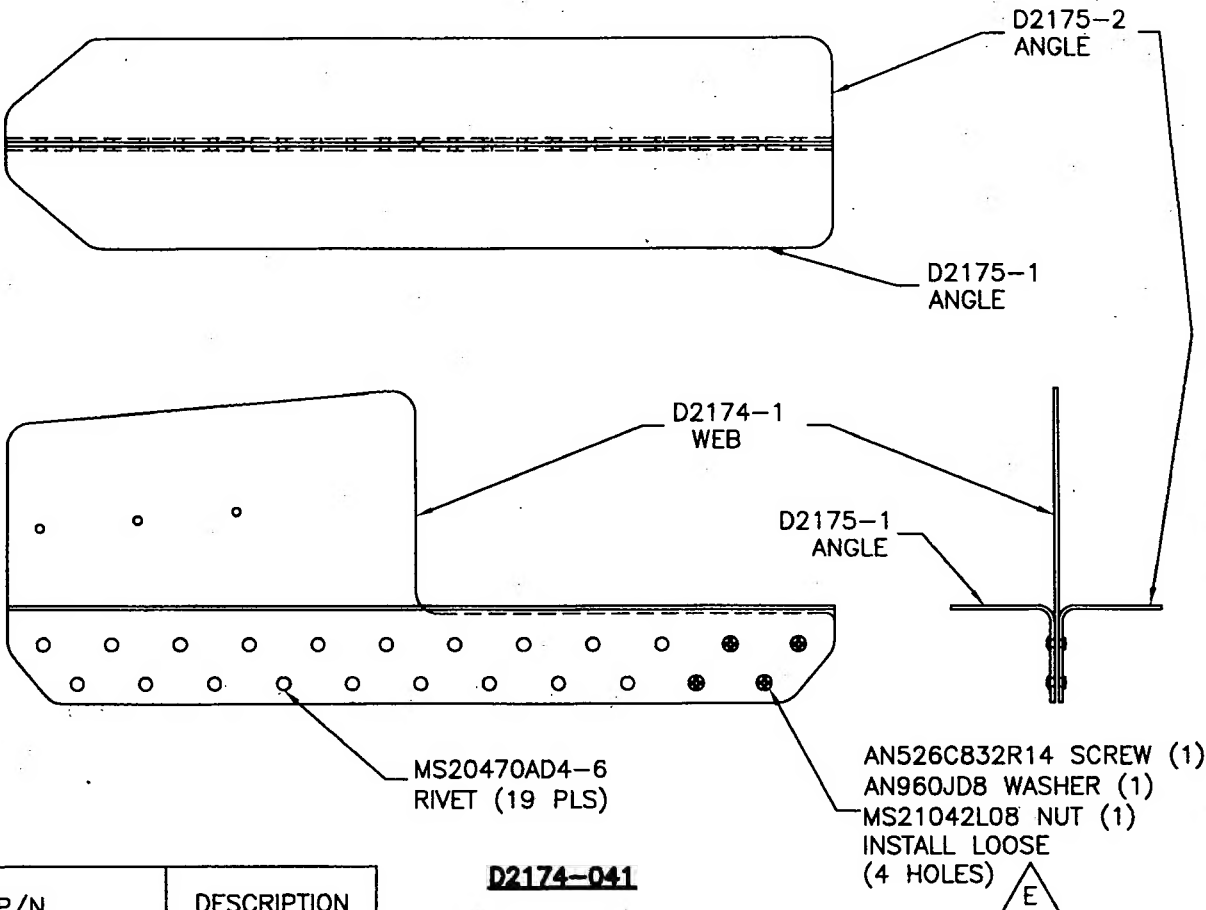


DESIGN RF DRAWN BY CE
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

CHECKED PH APPROVED PH
DRAWING NO. D2174
SHEET 1 OF 2
REV. E

DATE 06.09.25
TITLE WEB ASSEMBLY
SCALE 1:3

A	95.10.25	NEW ISSUE
B	96.01.18	RE-DRAWN
C	00.09.11	UPDATE FINISH SPEC.
D	04.06.03	RE-DESIGN
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE



D2174-041

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 27241
WORK ORDER

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

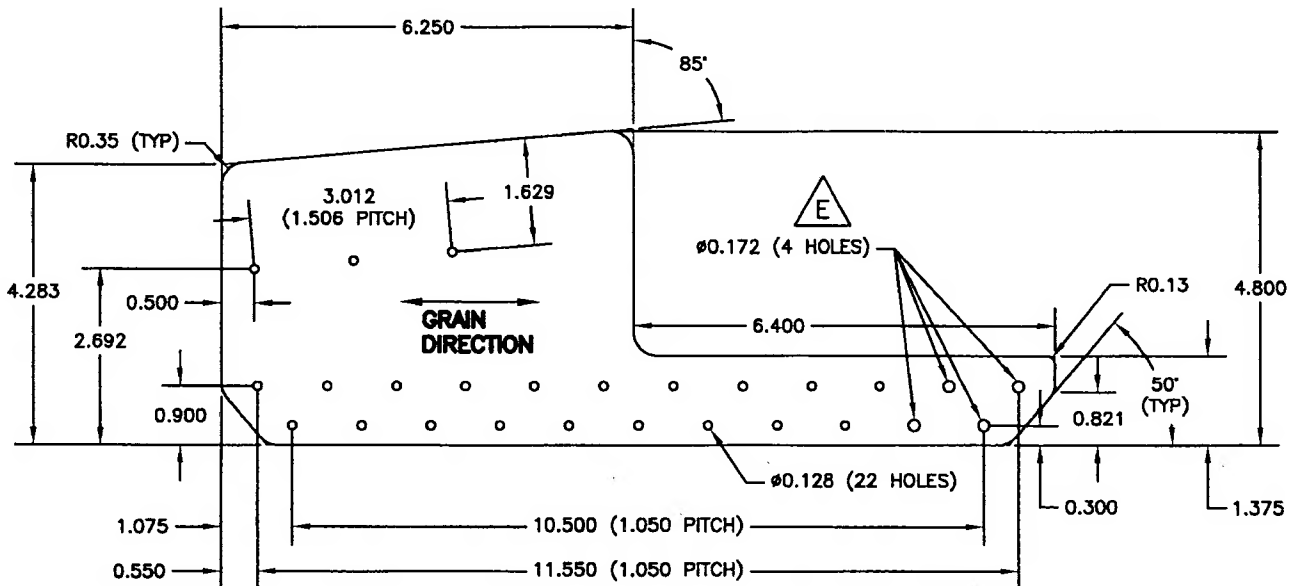
NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06.10.13

DART

DESIGN	RF	DRAWN BY	CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	PH	APPROVED	[Signature]	DRAWING NO. D2174	SHEET 2 OF 2
DATE	06.09.25	TITLE	WEB	SCALE	1:3



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER
37741

RELEASED
06.10.23

